

Work Order ID 84478

84478

Page 1

May-15-12 1:04:41 PM

Item ID: D206-642-412

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 *1*

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	0

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-412

CHG006

0.00

0.00

5/16/12

12-6-11

Work Order ID 84478

84478

Page 2

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Item ID: D206-642-412

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 ***1***

Customer:

Reference: rework - ECN09-531

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

101

0.00

101

HandFinish

Hand Finishing

Memo

0.00

PULL FROM HK:

1 X D206-642-411 B39120

UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440

REMOVE WEARPLATES:

6 X D2648-3 B34591

1 X D2656-15 B34596

1 X D2656-23 B34597

1 X D2656-37 B34510

1 X D3429-1 B34609

RETURN TO STK

DISCARD HARDWARE

ADD:

6 X D3537-1 B _____

1 X D3537-3 B _____

1 X D3535-15 B _____

1 X D3536-15 B _____

1 X D3535-23 B _____

1 X D3536-23 B _____

1 X D3535-37 B _____

1 X D3536-37 B _____

60 X MS27039C1-08 B _____

60 X AN960C10L (NAS1149C0332R)

B _____

DART		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL #09-39		FAX: 1-613-632-4443	
P/N	D206-642-412	GRG	CHG004
DESC	Skidtube RH High	SUC	SH98-4
LOT	B39120	SIC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	SIC	
US PATENT # 5735384		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

1 / 1 BR12-6-5.

Work Order ID 84478

84478

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Item ID: D206-642-412 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
105									
QC	Memo	0.00							
Quality Control									

8/17/06/07

Work Order ID 84478

84478

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Item ID: D206-642-412 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging		0.00							
-----------	--	------	--	--	--	--	--	--	--

Packaging									
-----------	--	--	--	--	--	--	--	--	--

Memo

REMOVE FROM KIT TO UPDATE TO CHG006:

1 X D2707-043(OR D2968-043)-SCRAP 37380
 1 X AN960JD1016 B
 1 X AN970-4 B 107715
 1 X MS21041 B 107321
 1 X AN4-5A B 106605
 1 X AN960JD416 B 107321
 1 X D2655 B 34613
 RETURN TO STK

ADD TO KIT:

1 X D3407-043 B
 1 X D3456-1 B 81826
 2 X D3457-1 B 81977
 1 X MS21043-4 B 121162
 1 X AN4C5A B 119017
 1 X AN960C416 B 119077
 1 X D3413-1 B 83307

12/6/12

Work Order ID 84478

84478

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May-15-12 1:04:41 PM

Item ID: D206-642-412 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging Packaging	Packaging Memo REPACKAGE USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-412 Location: <u>82</u> PPP Rev: <u>2</u>	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

12/6/22
MLJ 12/06/21

Picklist Print

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Page 1

Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11 Revised picklist per CHG004KJ/CP/JLM
IPP Rev:L 07-12-05 ECN 1080p DD verified by:ec
IPP Rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463I	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

1066050

1

1

111909750

-1

1

1107321 12/6/75

Picklist Print

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Page 2

Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000
Washer

-1 M 107713

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-412 Manufactured No Each 2.0000
Skidtube RH

1 84478 SL

Location	Loc Qty	Loc Code
FG081	1	
78487	1	
FG082	1	
41319	1	

D2648-3 Manufactured No Each 9.0000
Wearpad

-6 BL 126-5.

Location	Loc Qty	Loc Code
ST 34/591	-10	
81513	9	
ST237A	19	

6

D2655 Manufactured No Each 30.0000
Ring

-1 B34613SD

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

12/1/78

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-15 Manufactured No Each 6.0000
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
FP 34596	5	
83601	5	
Mezz	1	
51455	1	

1

D2656-23 Manufactured No Each 9.0000
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz 34597	9	
43407	2	
51468	7	

1

D2656-37 Manufactured No Each 21.0000
Wearshoe

-1

BL 12-6-5.

Location	Loc Qty	Loc Code
Mezz	21	
34510✓	2	
44550	7	
46497	1	
53019	11	

1

S D3407-043 Manufactured No Each 14.0000
Tow Ring

8¹³ 325 JCR sp

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

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Shop Packet Print

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Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3413-1 Ring Manufactured No Each 73.0000

1

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

D3429-1 Wearpad Manufactured No Each 16.0000

-1

Location	Loc Qty	Loc Code
FP002 34609.	16	
40438	2	
43706	1	
44579	12	
65692	1	

D3456-1 Washer Manufactured No Each 168.0000

1

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

Picklist Print

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Work Order ID: 84478
Parent Item: D206-642-412
Parent Item Name: Skidtube RH

Start Date: 5/14/12
Start Qty: 1.00

Required Date: 5/14/12
Required Qty: 1.00

D3457-1
Washer

Manufactured No Each 35.0000

2 *SP*

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

D3535-15
Wearshoe

Manufactured No Each 17.0000

1 *BR 12-6-5*

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

D3535-23
Wearshoe

Manufactured No Each 22.0000

1 *BR 12-6-5*

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

D3535-37
Wearshoe

Manufactured No Each 4.0000

1 *BR 12-6-5*

Location	Loc Qty	Loc Code
FP001	4	
71668	4	

D3536-15
Gasket

Manufactured No Each 20.0000

1 *BR 12-6-5*

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No Each 16.0000 1 BR 1265
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000 1 BR 1265
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623 ✓	12	

D3537-1 Manufactured No Each 41.0000 6 BR 1265
Wearpad

Location	Loc Qty	Loc Code
FG 84091	10	
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

D3537-3 Manufactured No Each 28.0000 1 BR 1265
Wearpad

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042-4
USE MS21042L4

Purchased No

Each 1,071.0000

-1

M107478.5

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

MS21043-4
Nut

Purchased No

Each 1,546.0000

1

12/6/7.5

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08
SCREW

Purchased No

Each 1,142.0000

60

62.5

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308✓	354	
121068✓	108	
121162✓	660	
ST293	19	
116373	3	
118077	14	
119309	2	

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Shop Packet Print

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Picklist Print

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Work Order ID: 84478

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each 3,354.0000

60

BL12-6-5.

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3135

121255

11

121509✓

3124

60

84478

Dart Aerospace Ltd.

Date: Thursday, 08/05/2008 11:58:40 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L/L3/L4 HIGH GEAR SKID
Job Number : 39120	
Estimate Number : 10526	
P.O. Number :	Part Number : D206642412
This Issue : 08/05/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : L
Previous Run : 39119	Material :
Written By :	Due Date : 30/05/2008 Qty: 1 Um: Each
Checked & Approved By : JLD 08.5.08	
Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-05 ECN 1080p DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL JLD 08.5.12
Photocopy blueink and create labels per PPP D206-642-412 CHG004 S 08/07/08

2.0	39120A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------



Comment: Sub-Component 206 L HIGH GEAR SKIDTUBE
D206-642-441 B 39120A S

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

4.0	D20664811	GHW Modification
-----	-----------	------------------



Comment: Qty. 1 (100) Each(s)/Unit Total : 1.0000 Each(s)
GHW Modification kit
Batch: 96/100 sel

5.0	D2652	Bushing
-----	-------	---------



Comment: Qty. 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Pick Packing Kit
Qty Part Number Description Batch
16 D2652 Bushing 38815
1 D206-642-441(REF) 8/5/06 S

Date: Thursday, 08/05/2008 11:58:41 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

D2655

Ring



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D2655

Tow Ring

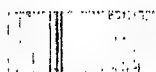
34163

scf

7.0

D2712

Set Screw



Comment: Qty: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: 10.0000

Qty Part Number

Description Batch

10 D2712

Set Screw

34602-8

scf

8.0

D25912

Saddle RH Out, 206



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D25912

Saddle

37265 (=1)

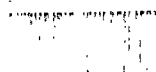
39772

scf

9.0

D25912

Saddle RH In, 206



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D25912

Saddle

37265 (=1)

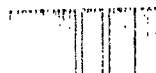
39889

scf

10.0

D2655

Saddle Spacer



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: 2.0000

Qty Part Number

Description Batch

2 D2655

Saddle Spacer

37328

scf

11.0

D2655

Saddle Spacer



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: 2.0000

Qty Part Number

Description Batch

2 D2655

Saddle Spacer

37867

8/5/06

scf

Date: Thursday, 08/05/2008 11:38:41 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

12

D29532

Saddle RH Out, 206



* 39120 8/6/26



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D29532

Saddle

~~39120~~

8/6/26

SP

13

D29392

Saddle RH In, 206



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D29392

Saddle

~~39120~~

8/6/26

SP

14

D29392

Tow Ring



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D29392

Tow Ring

~~39120~~

SP

15

AN341A

Bolt



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: 8.0000

Qty Part Number

Description Batch

8 AN341A

Bolt

~~101242~~

SP

16

AN45A

Bolt



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: 1.0000

Qty Part Number

Description Batch

1 D20664

Bolt

~~106605~~

8/5/26

SP

Date: Thursday, 08/05/2008 11:58:41 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description :

10

AN46A

Bolt



Comment: Qty: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick Packing Kit

Qty Part Number

Description Batch

12 AN46A

Bolt 106642

50

11

AN513

Bolt



Comment: Qty: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch

106642

50

12

AN512

Bolt



Comment: Qty: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick Packing Kit

Qty Part Number

Description Batch

4 AN512

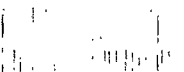
Bolt 104885

50

20

AN511

Bolt



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

Batch

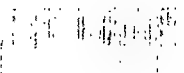
105810

50

21

AN960

Washer



Comment: Qty: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick Packing Kit

Qty Part Number

Description Batch

8 AN960-D10

Washer 9231

50

8/5/06

50

Date: Thursday, 08/05/2008 11:58:41 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 39120

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

QC4

INSPECT 10 Kits FOR COMPLETENESS



Comment: INSPECT 10 Kits FOR COMPLETENESS

5062412 (40)

29.0

PACKA:

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Ident: and for shipping as per PPP D206-642-412

Local:

PPP:

30.0

QC21

FINAL INSPECTION W/O RELEASE

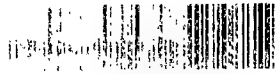
10/1/3 (1)



08/07/08

Comment: FINAL INSPECTION W/O RELEASE




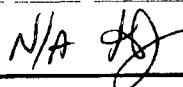
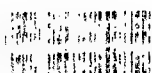



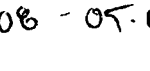
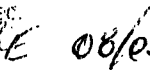
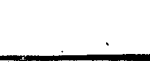
Job Complete:



mf 08-07-04

39120A

Process Sheet

Customer	: CU-DAAR001 Dart Helicopters Services	Drawing Name	: 206 L HIGH GEAR SKIDTUBE
Job Number	: 39120A		
Estimate Number	: 10522		
P.O. Number	:	Part Number	: D206642441
This Issue	: 06/05/2008 S.C. No. :	Drawing Number	: D2650 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SKIDTUBES	Drawing Revision	: E
Previous Run	: 30119A	Material	:
Written By	:	Date	: 30/05/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JD 08.508</u>		
Comment	Es. Rev. h. 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM Es. Rev. 08-05-01 add D03 DD verified by EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Operation:	Description:	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DC DOCUMENT CONTROL			
	Pho. : 08-05-01 add D03 DD verified by EC	CHG002	N/A 
2.0	D206	tube, 206 Skidtube	
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
			
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12
Comment: Qty. : 1.0000 Each(s) Unit : 1.0000 Each(s)			
	Part	Description	Batch
	D206	Tube, 206 Skidtube	32449
			08-05-12

Date: Thursday, 08/05/2004 11:59:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill holes for DTG 125 & DTS 110 (A,B,C,D). Open to Ø0.312".

7-Drill holes for crosshairs using E.T. 8028-7. Open to Ø0.297".

8-Drill holes for #0 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650 D2650-7 Drilling Detail

10-Flame treat the bearing flange on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 8-5-13

Hand Finishing Resource #1

Hand Finishing Resource #1



Comment: HAND FINISHING RESOURCE #1

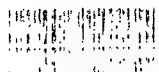
Check for proper fit of Dots as per QSI 005 4.1

SL 8-5-13

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



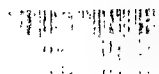
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D W 8-5-13

7.0

D2654

Hand



Comment: Qty. 100 (100) Each Total 1,000 Each

Prod

Description

Batch

Wen

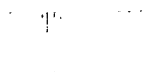
24594

SL 8-5-13

8.0

SKIDTUBE

SKIDTUBE RESOURCE 1



Comment: SKIDTUBE RESOURCE 1

1-Drill holes for crosshairs as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Drill holes for crosshairs spacer holes as per Dwg D2650 (without cutting fluid)

3-Drill holes for crosshairs. Grind and line off around crosshairs spacer.

4-Bond D2654-7 into place as per QSI 0155 ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-5-13 Time: 12:35

Finish Date: 8-5-13 Time: 12:00

SL 8-5-13

Date: Thursday, 08/05/2008 11:59:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Doc. Number:



Seq. #:

Machine Or Operation:

Description:

A/R Skidex 291

07604

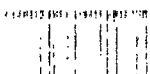
Skidex expiry date:

0720

9

QC

INSPECT WORK TO CURRENT STEP



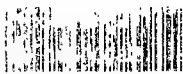
Comment: INSPECT WORK TO CURRENT STEP

08/05/14 06

10

D2049

Cross Bolt Spacer



Comment: Qty: 23.0000 Each(s)/Unit Total: 23.0000 Each(s)

Pick

Qty

Description

Batch

10 D2049

Cross Bolt Spacer

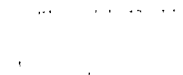
07604

08/05/14

11

D2049

SKIDTUBE RESOURCE 1



Comment: UNLOADING / CAR RESOURCE 1

1-Inch Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole
in the base of the welding rod. Use aluminum rod.

Weld as per QSI 004

07604

08/05/14

Weld as per Dwg D2650. Masking Tape access to inside of the Skidtube

SL 85-20

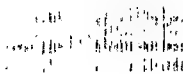
Skidex 291 A/R 0.750" deep as per Dwg D2650

SL 85-20

12

D2589

Nut Plate



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick

Qty

Description

Batch

12 D2589

Nut Plate

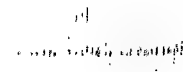
07604

SL 85-20

13

CCR251

Cherry Rivet



Comment: Qty: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick

Qty

Description

Batch

13 CCR251

Rivets

07604

SL 85-20

Date: Thursday, 08/05/2023 11:09:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

M7285343

Rivet



Comment: Qty: 2.000 Total(s) Total: 2.0000 Each(s)

Pick

X

QS Part Number

Description Batch

07285343

Rivets 107285343

SL 8-5-20

HAND FINISHING RESOURCE #1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Inspection: Visual inspection of ground welds per Dwg D2650

SL 8-5-20

16.0

QC

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

17.0

QC

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

QC

HAND FINISHING RESOURCE #1



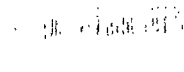
Comment: HAND FINISHING RESOURCE #1

Pow

19.0

Pow

POWDER COATING



Comment: Powder Coating

Pow: 005 White (R.F. 4.0, 5.1) per QS: 005 4.3

Take care: Do not use paint screw

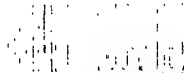
3:50 am
07:00 am
07:30 am

M-L 08/05/21

20.0

QC

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-05-21

Date: Thursday, 08/05/2022 11:59:05 AM
User: Julie Lecoq

Process Sheet

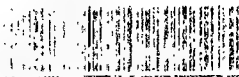
Customer: CU-DAIR001 Part Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 391204

Part Number: D206642441

Job Numt



Seq. #:

Machine Or Operation

Description :

21

D20664

Wearpad



Comments: Qty: 1 Unit: Total: 6.000 Each(s)

Pick

391204

Description: Batch

Wearpad

3445

71

BR.

22

D20664

Wearshoe



Comments: Qty: 1 Unit: Total: 6.000 Each(s)

Pick

391204

Description: Batch

Wearshoe

31576

76

BR.

23

D26562

Wearshoe



Comments: Qty: 1 Unit: Total: 1.000 Each(s)

Pick

391204

Description: Batch

Wearshoe

3447

77

BR.

24

D20664

Wearshoe



Comments: Qty: 1 Unit: Total: 1.000 Each(s)

Pick

391204

Description: Batch

Wearshoe

3440

70

BR.

25

D34291

Wearpad



Comments: Qty: 1 Unit: Total: 1.000 Each(s)

Pick

391204

Description: Batch

Wearpad

3449

09

BR.

26

A10400

Wear



Comments: Qty: 1 Unit: Total: 6.000 Each(s)

Pick

391204

Description: Batch

Wear

3449

09

BR.

BR 08-05-22

Date: Thursday, 08/05/2022 11:59:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DARPC Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 39120A

Part Number: D206642441

Job Number:



Seq. #:

Machining Operation:

Description:

32.1

MS27030-03

Screw



Amount: Qty. 1.000 Each (s) Total: 1.0000 Each(s)

Pick

Qty. 1.0000 Description: Batch

1.0000 Screw *batch 541*

33

MS27030-03

Cap



Amount: Qty. 1.000 Each (s) Total: 1.0000 Each(s)

Pick

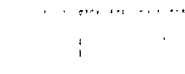
Qty. 1.0000 Description: Batch

1.0000 Air Cap *batch 377-35*

34

MS27030-03

AND FINISHING RESOURCE #1



Amount: Qty. 1.000 Each (s) Total: 1.0000 Each(s)

Pick

Qty. 1.0000 Description: Batch

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

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1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

1.0000 Sikaflex *batch 08-10*

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DISH-OUT WORK TO CURRENT STEP

08/05/22

Part Number D206-642-412
Description 206 SKIDTUBE INSTALLATION

[illegible]

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbte Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date	Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>LL 09.02.19</i>	DQA / QA Coord			
Production Engineering Coord	Y	EC/DD	<i>EC/DD 09.02.19</i>	QC Coordinator	Y	JM	<i>JM 09.02.19</i>
Production Document Control	Y	JLD	<i>JLD 09.02.19</i>	Marketing	Y	SW	<i>SW 09.03.11</i>
Customer Technical Support				Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:
DSI 9421 REV B
DSI 9440 REV A
D206-648 REV B
D3414 Rev B

PARTS MUST COMPLY

☐

PREVIOUS PARTS SATISFACTORY

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. 11</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

Description / Action:
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)
-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)
-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006
D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: [Signature]		
Product Name: Skidbe Installation	Checked By: [Signature]	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	11/09/02/19
Production Document Control	Y	JLD	3/09/02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	10/02.19
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:
DSI 9421 REV B
DSI 9440 REV A
D206-648 REV B
D3414 Rev B

PARTS MUST COMPLY ☐ PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

Description / Action:
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)
-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)
-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 respectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006
D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

N/A
JLD 09.03.03

ECN Verified & Complete: _____ Date: _____

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	NA	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	WEARSHOE CHANGE	NTS
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

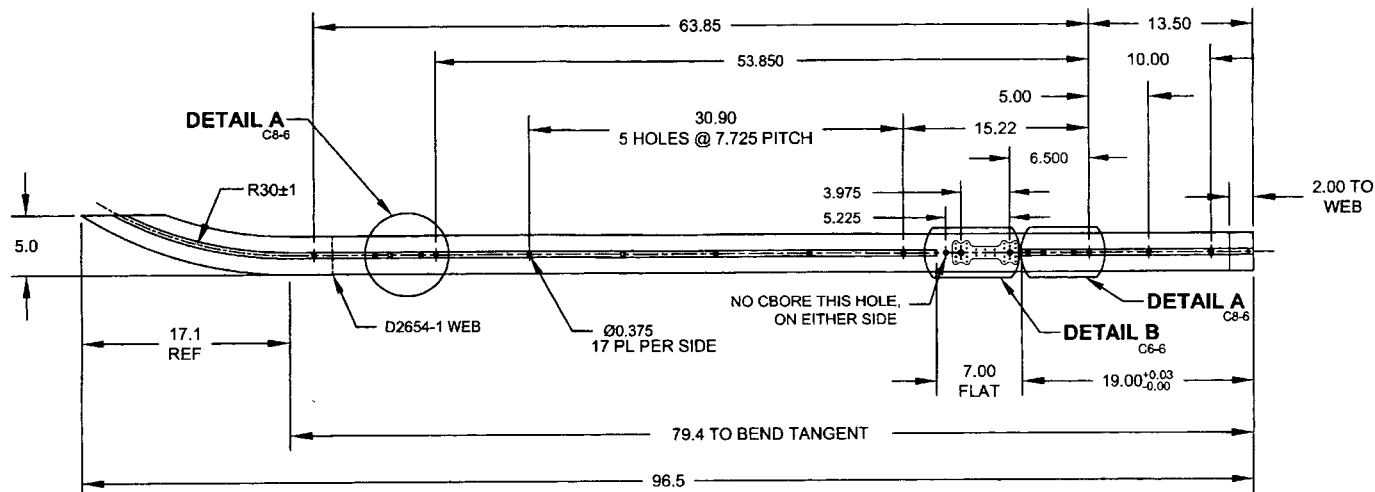
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08-23-78

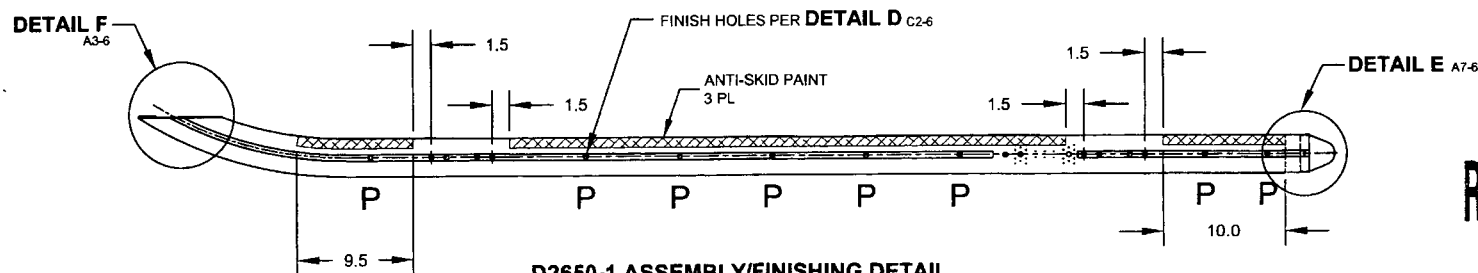
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL 20.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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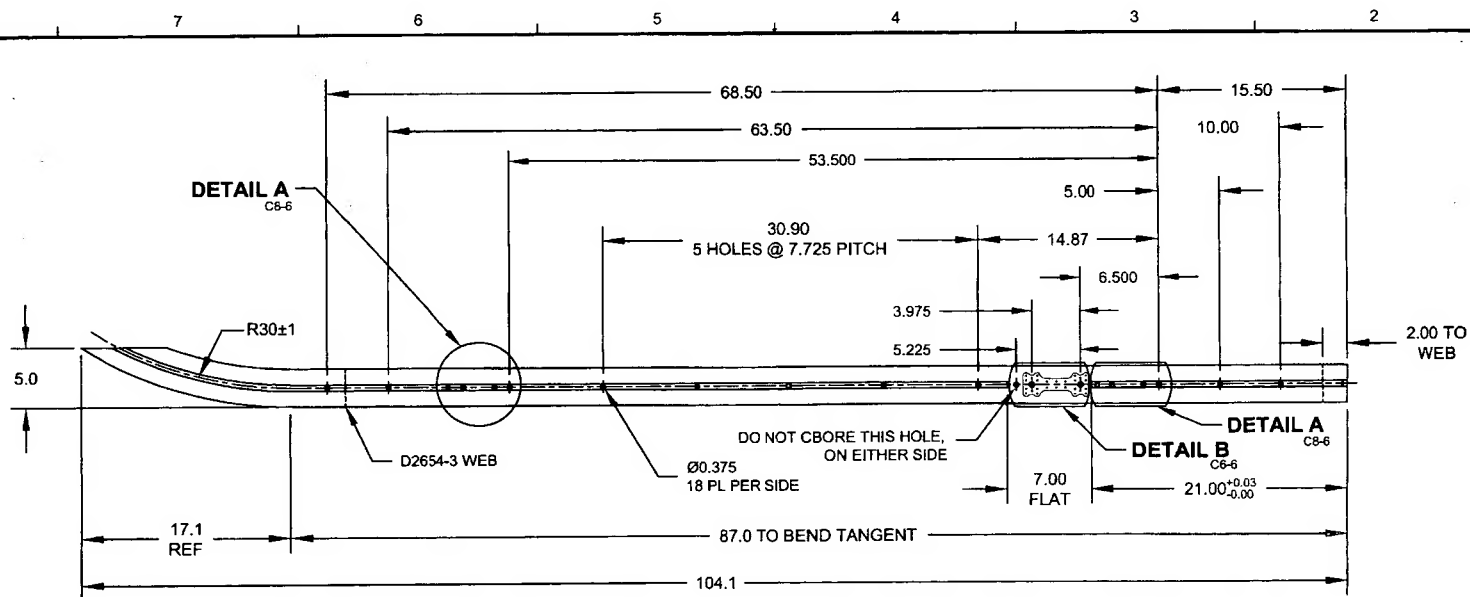
D2650-1 BENDING/DRILLING DETAIL



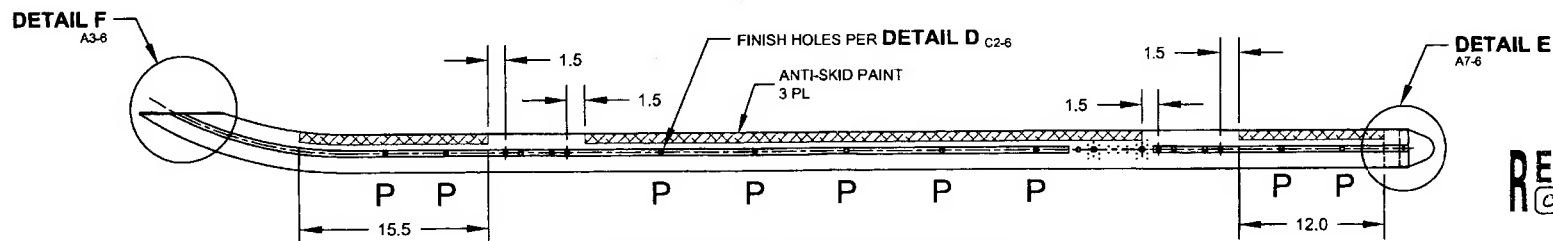
D2650-1 ASSEMBLY/FINISHING DETAIL

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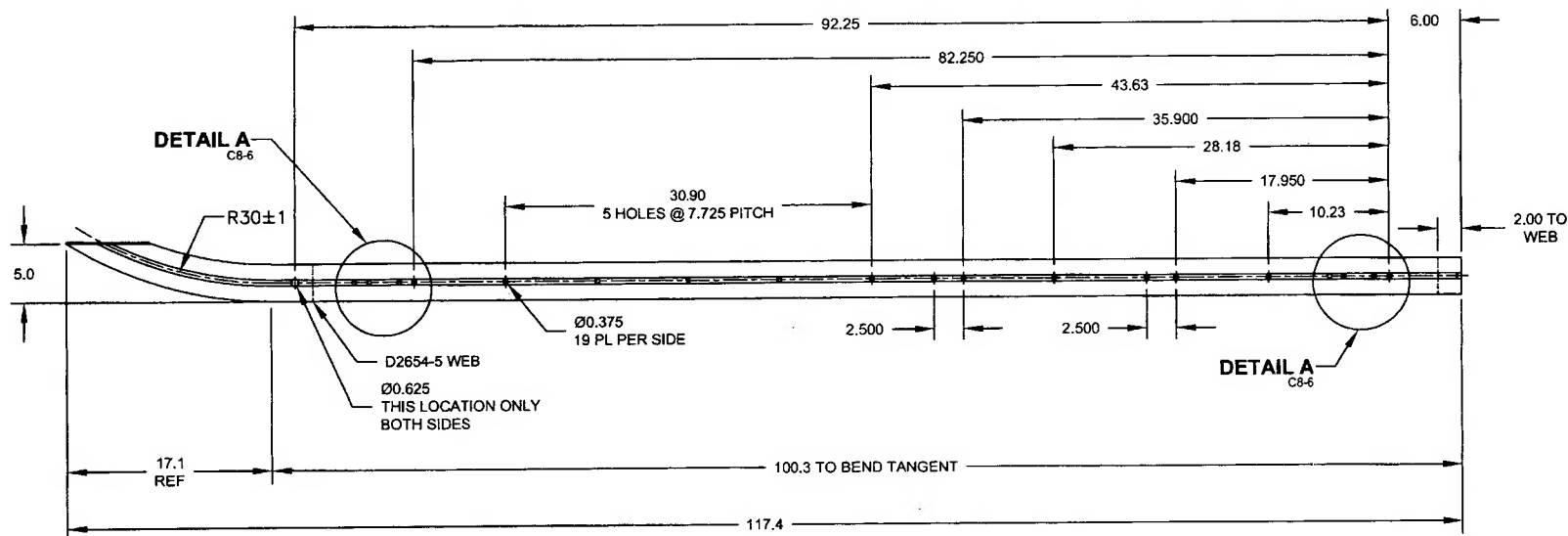


D2650-3 BENDING/DRILLING DETAIL

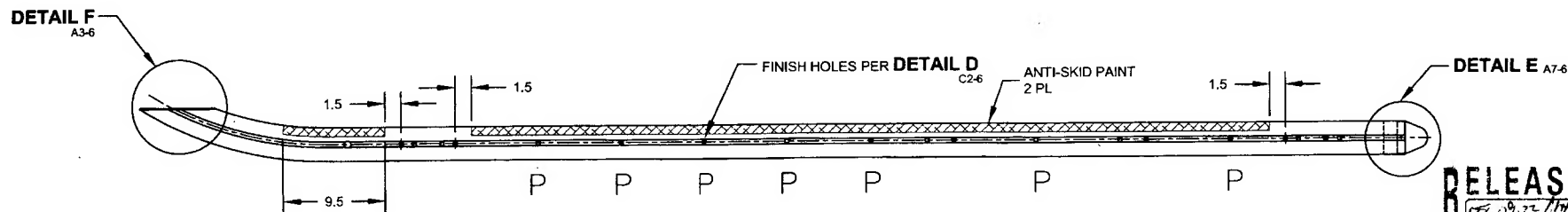


D2650-3 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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APPROVED		TITLE	SCALE
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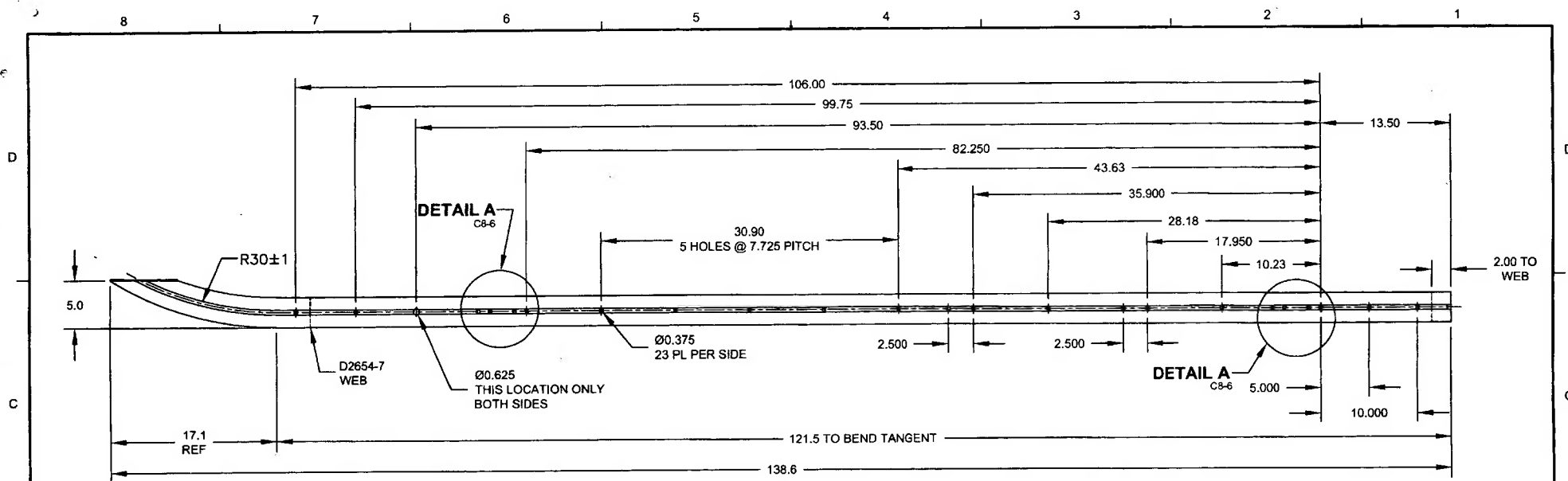
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

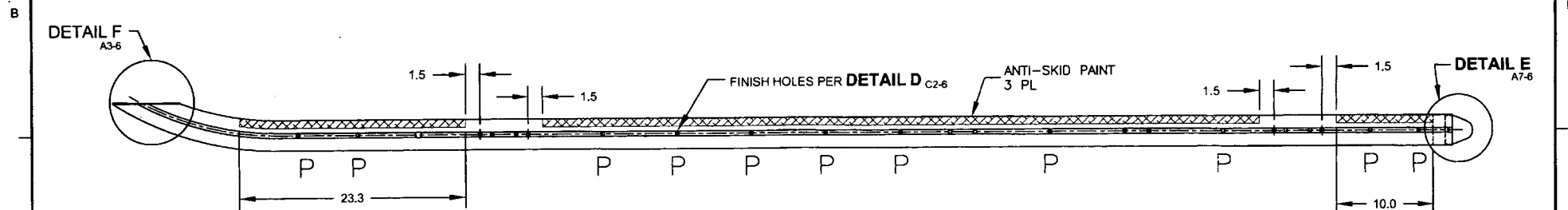
RELEASED
09/22/11

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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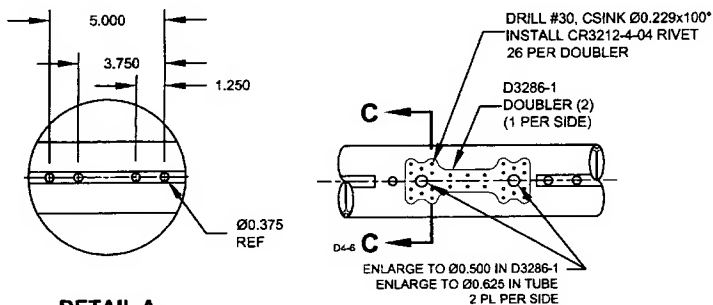
D2650-7 BENDING/DRILL DETAIL

RELEASE
04 07 22



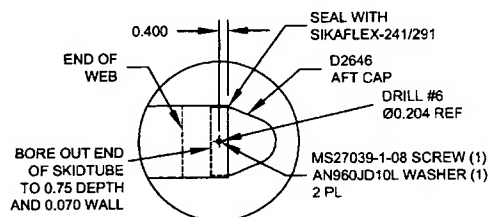
D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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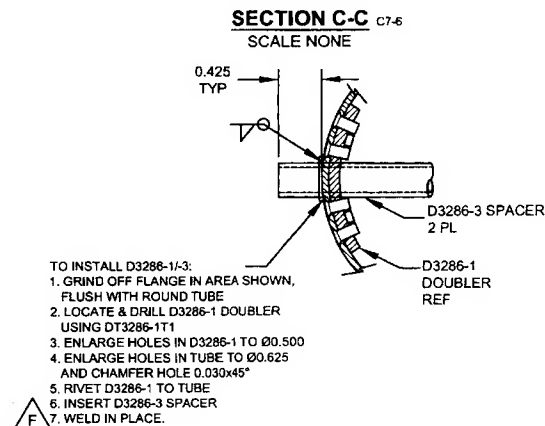


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

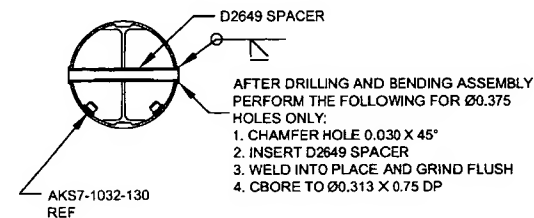
DETAIL B
SCALE 2X
C3-2
C3-3



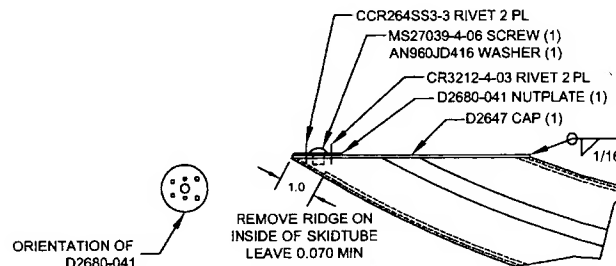
DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



F



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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08.08.08

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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